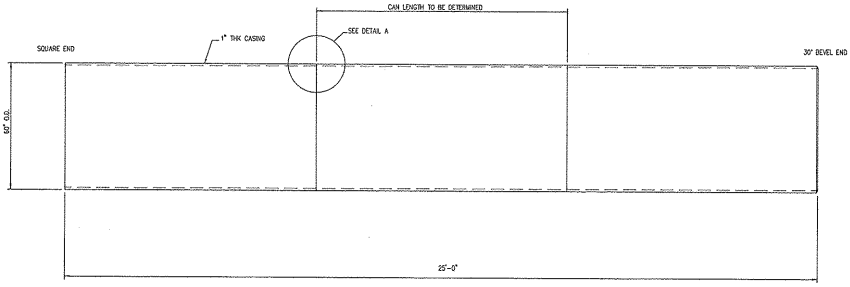
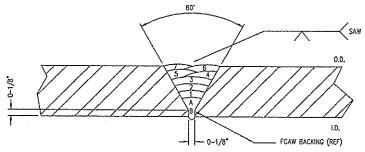


SPOOL No/ 60100-3

60" O.D. x 1.00 WALL



FCAW- SAW- WPS- 01
A. FCAW (GAWD WELD FROM OUTSIDE)
B. FCAW (BACKGOUGE THEN HAND WELD FROM INSIDE)
1 thru 7 SAW (MACHINE WELD, MULTIPLE LAYERS REQ'D TO COMPLETE WELD)

DETAIL A

TYPICAL WELD JOINT
CIRCUMFERENTIAL & LONGITUDINAL
NO SCALE
(SECTION CUT FOR CLARITY)

VTrans
Received
CK'D_____ OK'd BY JWC

MAY 11 2012

Resubmit_____APPROVED
BY_____DATE_____

GENERAL NOTES:

1. ALL WELDS TO BE CONTINUOUS WITH FULL PENETRATION, PERFORMED BY CERTIFIED WELDERS PER A
2. PIPE TO BE MANUFACTURED IN ACCORDANCE WITH ASTM A139 GR. B WITH THE EXCEPTION OF THE WAIVED BY THE STATE OF VERMONT AS DOCUMENTED IN WRITEN ORDER #18.

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REV. NO.	DATE	BY	DESCRIPTION

PROJECT NUMBER: IM OLLV (23)
COMPANY: Bore Tech LLC. St. Johnsbury, VT.
PROJECT NAME: South Burlington- Colchester
DRAWN: MBE | SCALE: NONE | DATE: 4/26/12 | CHK'D: | REF:

Valiant Steel and Equipment, Inc.
6455 Old Peachtree Road
NORCROSS, GEORGIA (770) 417-1235

DWG. NO. 60100